

Work Order ID 65147

Thursday, January 06, 2011 3:30:57 PM



Page 1

Item ID: D3565-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 1/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: PLDate: 1-1-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3565

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3565 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

304 . 063

B11-1-11

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-1-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 1/10

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Item ID: D3565-1

Accept

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Start Date: 1/6/2011 Start Qty: 8.00

Required Date: 1/14/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M 112588

Memo

0.00

Powder Coating

START TIME:

8:40

OVEN TEMPERATURE:

3:20 FINISH TIME:

9:10

9 BR11-01-14

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9 9/11 1/10/11

180

Identify as per dwg & Stock Location: 497A

0.00



Packaging

Memo

0.00

Packaging

10 1/17 2(9)

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Item ID: D3565-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 1/6/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/17 JG
MF

11-01-17

Picklist Print

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Page 1

Work Order ID: 65147



Parent Item: D3565-1



Parent Item Name: Wearplate



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev :A New Issue 07-01-16 JLM
 IPP rev B revB dwg 07.04.18 ec
 IPP Rev:C rev.c as per dwg 08-01-14 DD verified by:
 IPP Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3009-3  Cup		Manufactured	No			100	Each	117.0000	3	24			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		117							
				42377		117				27		11-1-13	
M304S16GA  304/316 Sheet .063		Purchased	No			130	sf	34.8100	0.135	1.136842			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		34.81							
				111323		0							
				115953		34.81				115953			

(9)

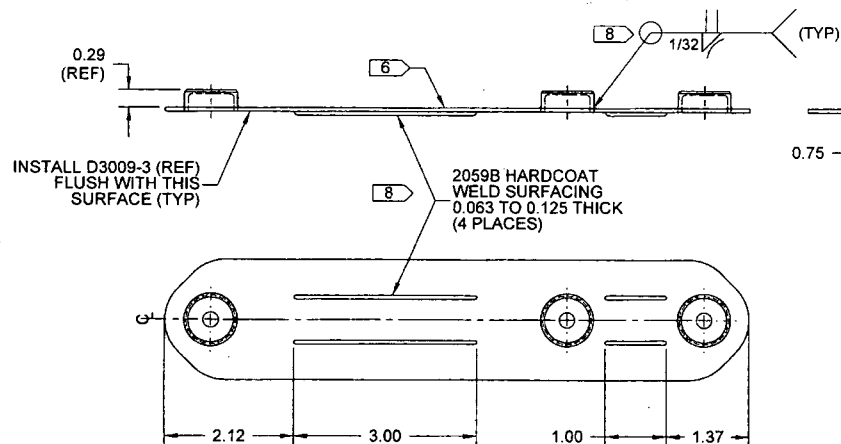
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

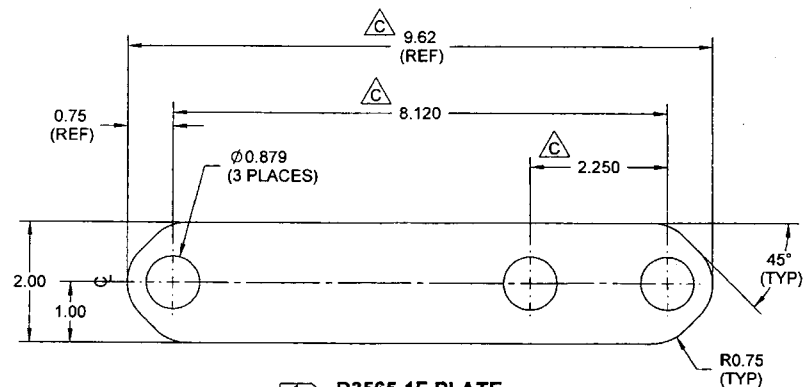
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

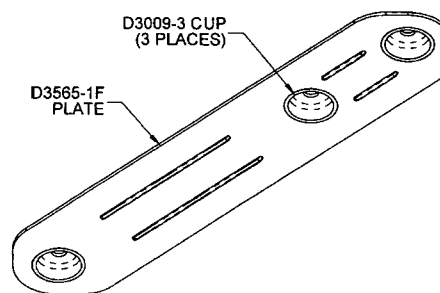
NOTE: Date & initial all entries



D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

QTY -1	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDING" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65147

2111-01-7 RELEASED
86-01-11-11

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CB		
DRAWN	CB		
CHECKED	CB		
MFG. APPR.	CB		
APPROVED	CB		
DE APPR.	CB		
DATE	07.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3565** REV. C
TITLE **R44 WEARPLATE** SCALE 1:2
SHEET 1 OF 1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries